

Work Order ID 116758

116758

Page 1

July-10-14 10:49:24 AM

Item ID: D3777-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Clamp
 Start Date: 4/30/14 Start Qty: 14.00 ***14*** Cust Item ID:
 Required Date: 4/30/14 Req'd Qty: 14.00 ***14*** Customer:
 Reference:

Approvals: Process Plan: MW Date: 14-07-10 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3777	Rev A								

100 FLOW WATER JET 0.00
100 Waterjet 0.00 (16) mm 14/07/16
 FLOW CNC Waterjet Memo 1-Cut as per Dwg D3777-1 Dwg Rev: A Prog Rev: A 2-Deburr if necessary

110 QC2- Inspect parts off machine FAI/FAIB 0.00
110 QC 0.00 (16) mm 14/07/16
 Quality Control Memo

120 QC8- Inspect parts - second check 0.00
120 QC 0.00 4/1/17 K6
 Quality Control

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Item ID: D3777-041

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Clamp

Stop *NS2*

Start Date: 4/30/14

Start Qty: 14.00

14

Cust Item ID:

Required Date: 4/30/14

Req'd Qty: 14.00

14

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool # Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

130

Small Fab

Small Fab

Memo

0.00

0.00

DAS
30
9-89

16

14/07/21

Small Fab

1- Deburr any rough edges2- Form as per Dwg D3777

140

140

QC

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

DAS
27
9-89

4/7/21

16

Quality Control

150

150

Small Fab

Small Fab

Memo

0.00

0.00

16

FF
14-07-22

Small Fab

Assemble rubber cushion as per dwg D3777

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Revision ID: Stop ***NS2***
Item Name: Clamp
Start Date: 4/30/14 Start Qty: 14.00 ***14*** Cust Item ID:
Required Date: 4/30/14 Req'd Qty: 14.00 ***14*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160	QC5- Inspect part completeness to step on W/O	0.00				16			
160									
QC	Memo	0.00							
Quality Control									

170	Identify as per dwg & Stock Location: 81059	0.00							
170									
Packaging	Memo	0.00							
Packaging									

180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.00							
Quality Control									

DAS
26
9-89

14/7/22
mf
14-7-22

Picklist Print

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Work Order ID: 116758

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Parent Item: D3777-041

D3777-041

Parent Item Name: Clamp

Start Date: 4/30/14

Required Date: 4/30/14

Start Qty: 14.00

Required Qty: 14.00

Comments: IPP Rev:A new issue 08-05-26 DD verified by:EC
IPP Rev:B 08-10-20 revA as per dwg DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2182B013		Manufactured	No			100	Each	0.0000	1	14			
D2182B013					1151689				**			FF	14-07-22
Rubber Cushion													
M304S22GA		Purchased	No			150	sf	241.4900	0.02	1			
M304S22GA									**			mm	14/07/16
304/316 .032 Sheet													

Location

MAT020

m126593

Loc Qty

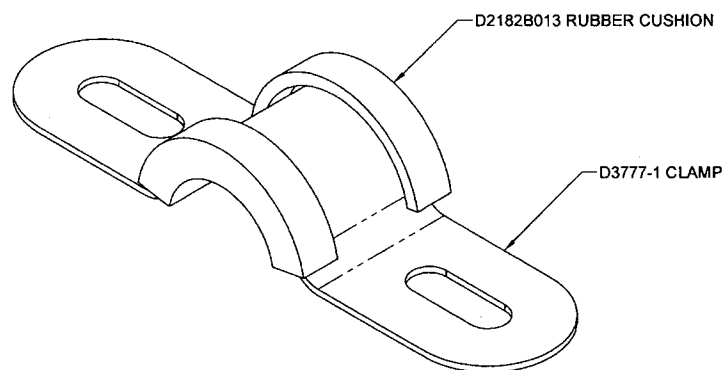
241.49

241.49

Loc Code

0.4

QTY	P/N	DESCRIPTION
-041		
X	D3777-041	CLAMP
1	D3777-1	CLAMP
1	D2182B013	RUBBER CUSHION



D3777-041 CLAMP

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: NONE
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.02 lbs

116758ML5
14-04-24

RELEASED
08-10-25

A	NEW ISSUE	CP	08.04.25
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.04.25		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D3777	REV. A
TITLE CLAMP	SHEET 1 OF 3
	SCALE NTS

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8

7

6

5

4

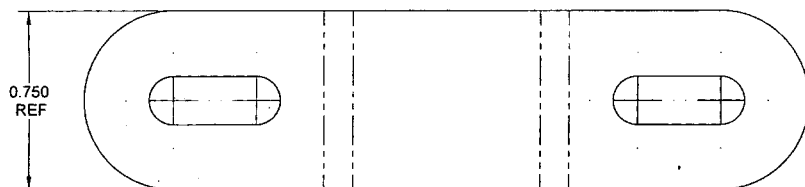
3

2

1

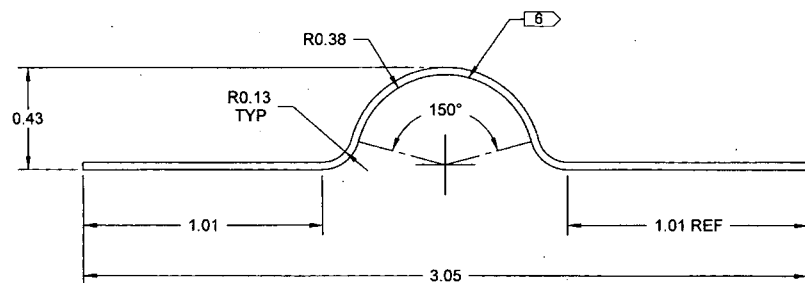
D

D



C

C



B

B

D3777-1 CLAMP

RELEASE
08-10-10

NOTES:

- 1) MATERIAL: MAKE FROM D3777-1F
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3777-1" USING FINE POINT PERMANENT MARKER
- 7) WEIGHT: 0.02 lbs

DESIGN	92	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	92		
CHECKED	PH	DRAWING NO.	REV. A
MFG. APPR.	MD	D3777	SHEET 2 OF 3
APPROVED	MY	TITLE	SCALE
DE APPR.	MY	CLAMP	NTS
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A

8

7

6

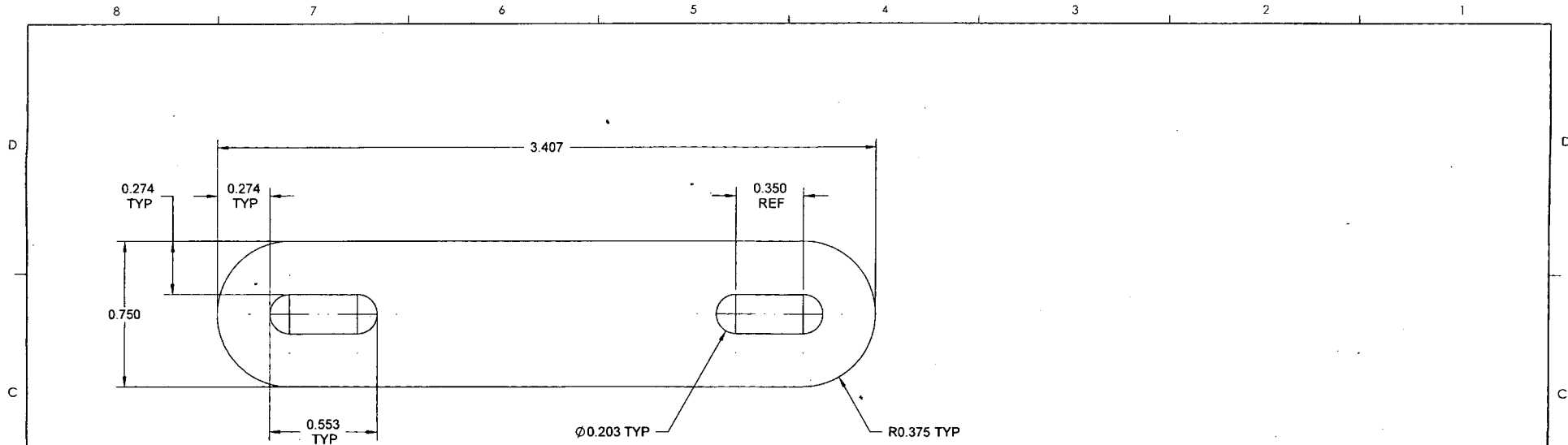
5

4

3

2

1



D3777-1F CLAMP

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 0.031 THICK (REF DART SPEC. M304S22GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.02 lbs

RELEASED
08-10-15/11

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